

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65930

Thursday, January 27, 2011 11:27:44 AM



Page 2

Item ID:	D3535-13	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearshoe					
Start Date:	1/27/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	2/7/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00				(12)			
Brake NC	Memo 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-13	0.00							
140 QC	QC5- Inspect part completeness to step on W/O	0.00				(112)			
Quality Control	Memo	0.00							
150 Powdercoat	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3	0.00							
Powder Coating	Memo START TIME: 3:20 FINISH TIME: 3:50	0.00							

SB 11/02/01

Sub 02/01

12 Bl 11-02-1

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Work Order ID 65930

Thursday, January 27, 2011 11:27:44 AM

Page 3

Item ID: D3535-13

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 1/27/2011 Start Qty: 10.00

Required Date: 2/7/2011 Req'd Qty: 10.00




Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		11/02/02		12	0		
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-18</u> Memo	0.00 0.00				12	BR	11-02-1	
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/02/02 MF 11-02-02

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NOTE: Date & initial all entries

Picklist Print

Thursday, January 27, 2011 11:27:50 AM

Page 1

Work Order ID: 65930



Parent Item: D3535-13



Parent Item Name: Wearshoe

Start Date: 1/27/2011

Required Date: 2/7/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

182.9000

0.8505

8.952632

10.3



304/316 .040 Sheet

1811-31

Location

Loc Qty

Loc Code

MAT

182.9

115953

32.1

116437

54.8

116623

96

116623

(12)

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DART AEROSPACE LTD		Work Order:	45930
Description: Wearshoe		Part Number:	D3535-13
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.891	✓		V H13-02	
2.000	+/-0.010	2.000	✓		V	
5.650	+/-0.010	5.650	✓		T	
9.150	+/-0.010	9.150	✓		T	
14.066	+/-0.010	14.066	✓		T	
18.983	+/-0.010	18.983	✓		T	
23.900	+/-0.010	23.900	✓		T	
27.400	+/-0.010	27.400	✓		T	
29.400	+/-0.010	29.400	✓		T	
32.900	+/-0.010	32.900	✓		T	
Ø0.188	+0.005/-0.001	.1190	✓		V	
20.00	+/-0.030	20.00	✓		T	
14.00	+/-0.030	14.00	✓		T	
8.00	+/-0.030	8.00	✓		T	
5.00	+/-0.030	5.00	✓		T	
0.300	+/-0.010	.301	✓		V	
0.300	+/-0.010	.302	✓		V	
0.038	+/-0.010	.039	✓		V	

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 11-1-31	Date: 11/2/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	DS

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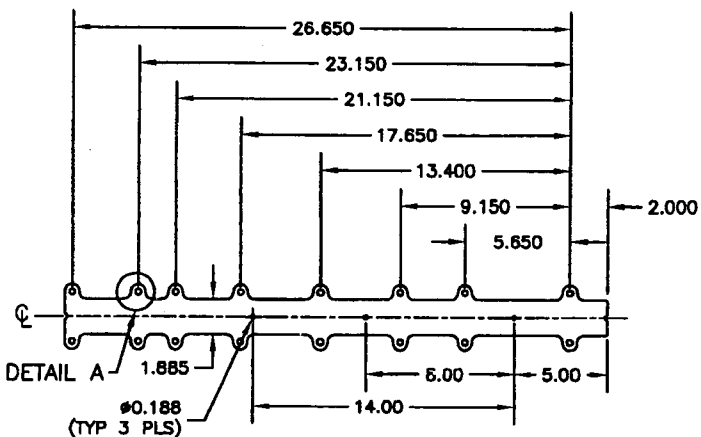
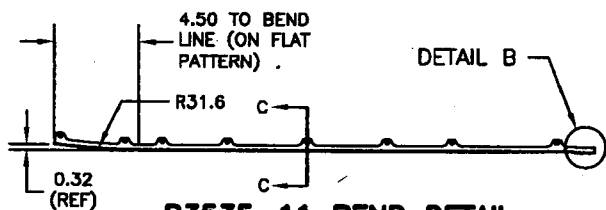
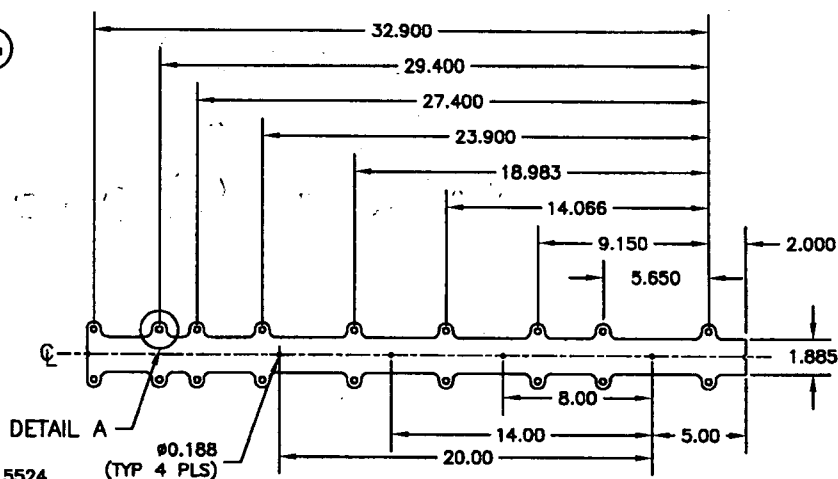
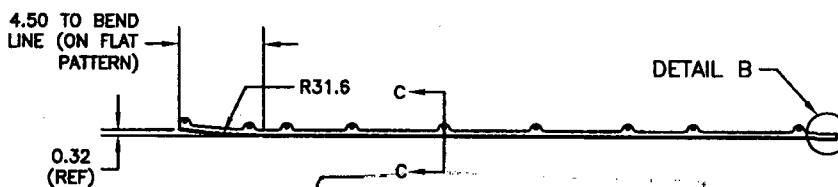
NOTE: Date & initial all entries

DART

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07.04.24

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45930

PL 11-01-27**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
		D3535	
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

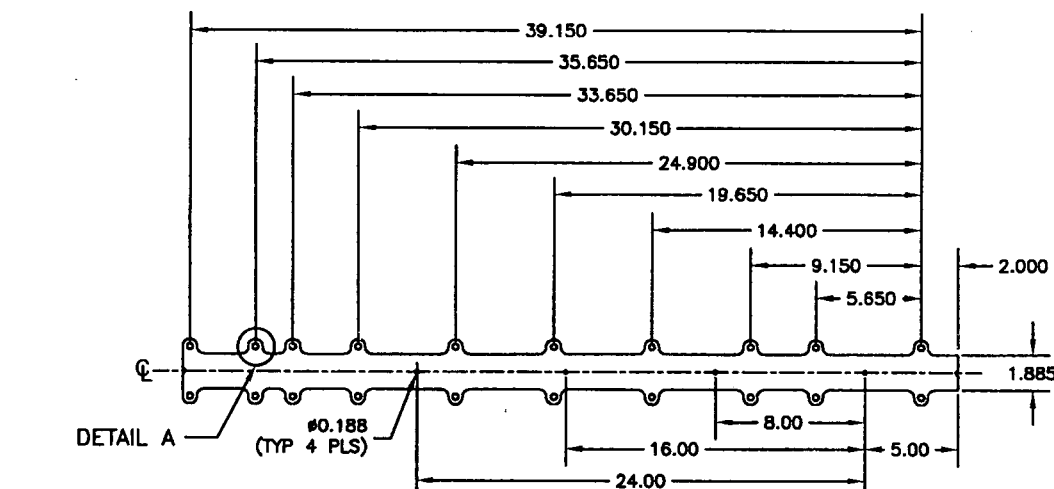
NOTE: Date & initial all entries

DART

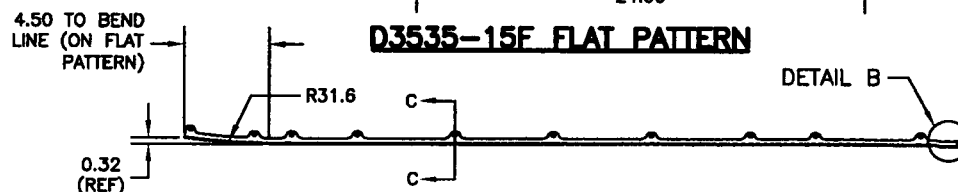
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07.04.24

W/ 65930

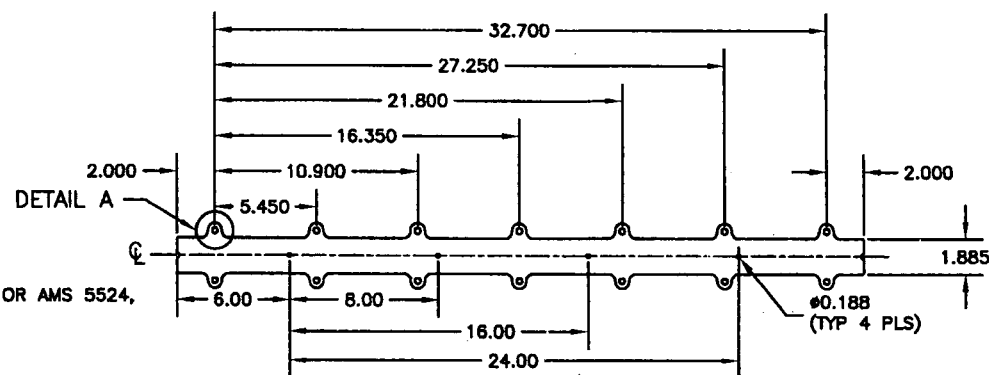
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
				REV. B
				SHEET 2 OF 7
				SCALE 1:10



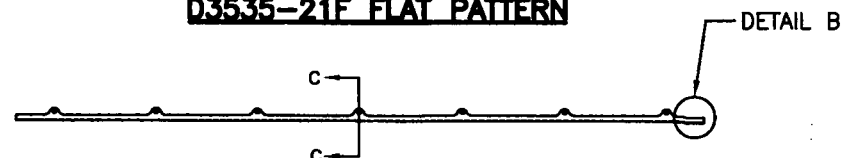
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

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- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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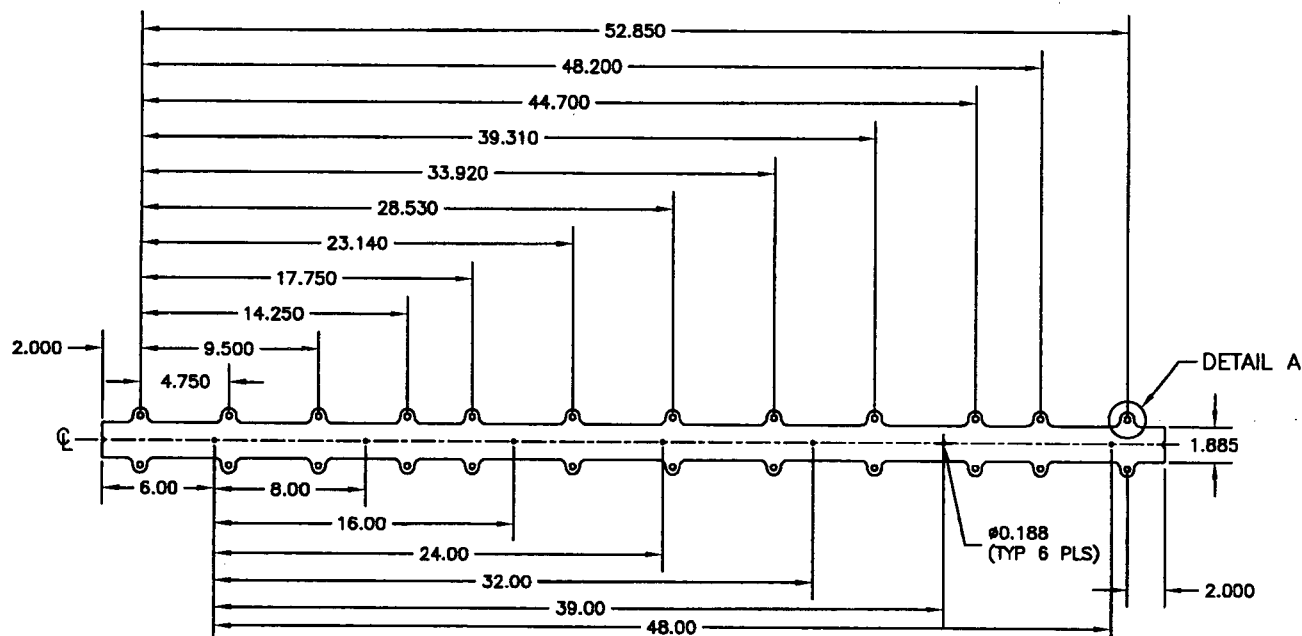
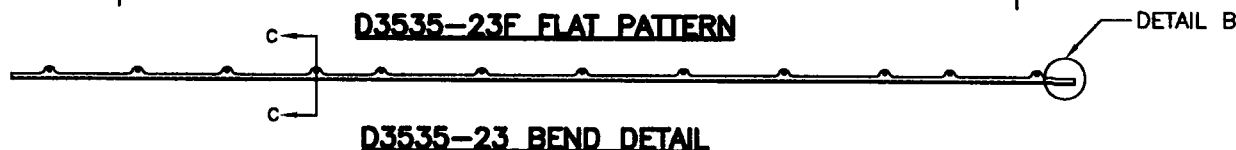
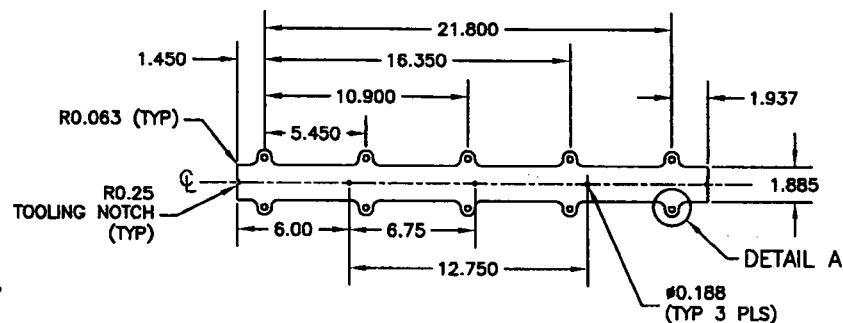
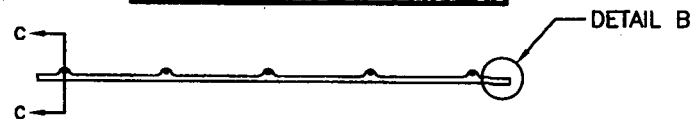
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
#	#	D3535	SHEET 3 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

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w/065930

**D3535-23F FLAT PATTERN****D3535-23 BEND DETAIL****D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL****NOTES**

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NOTE: Date & initial all entries

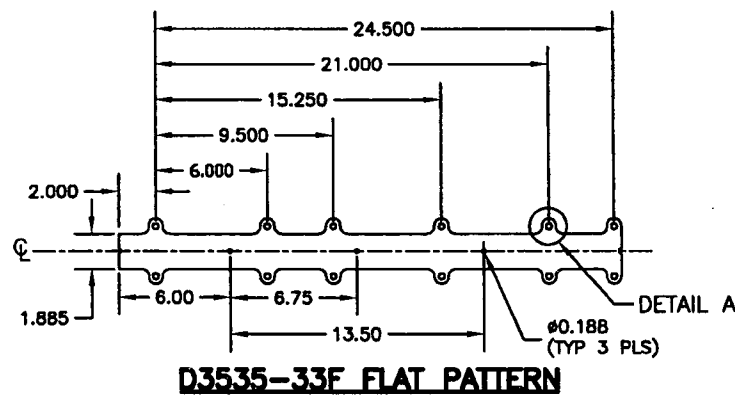
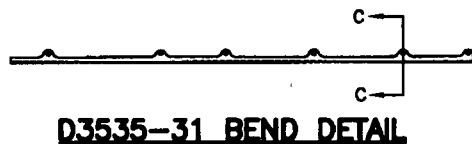
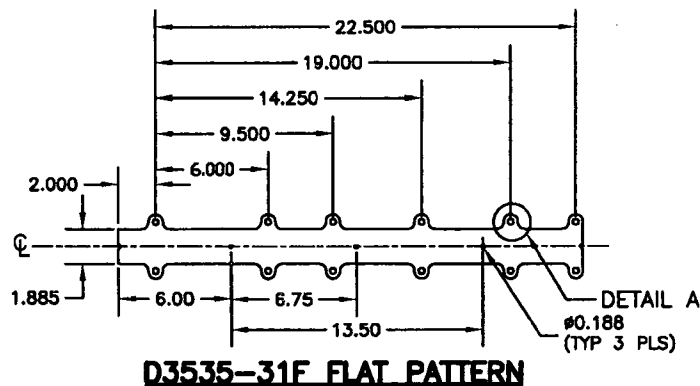
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	

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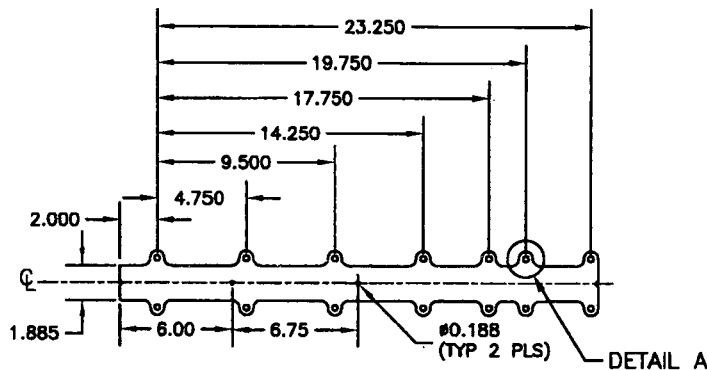
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07.04.17

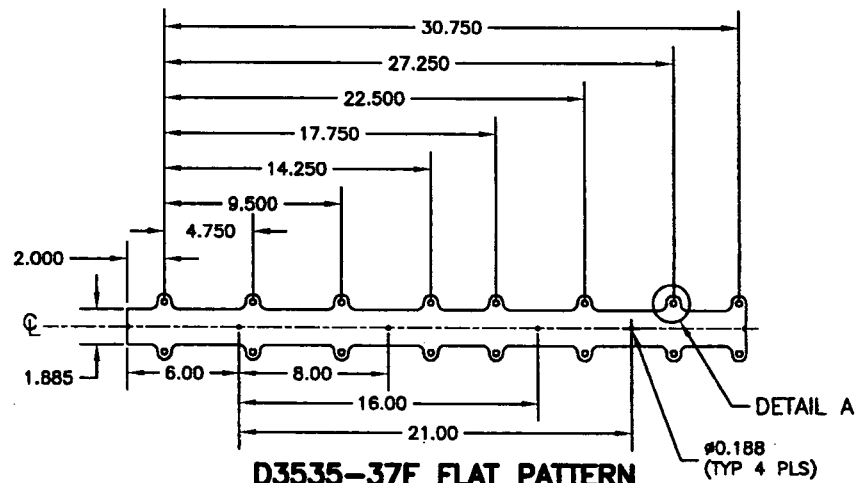
w/o 65930



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET 5 OF 7		
		REV. B		

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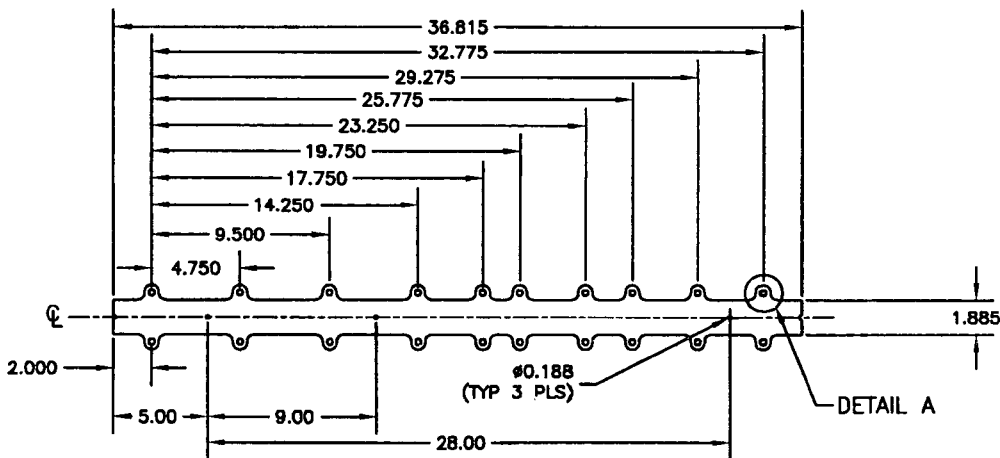
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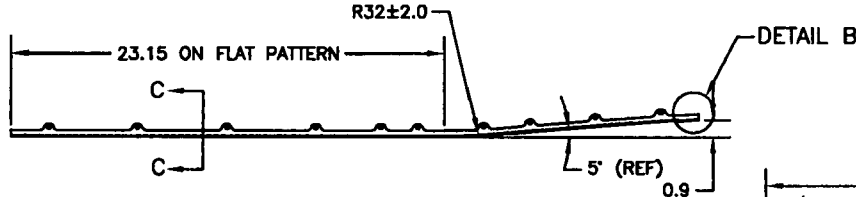
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WLO 65930

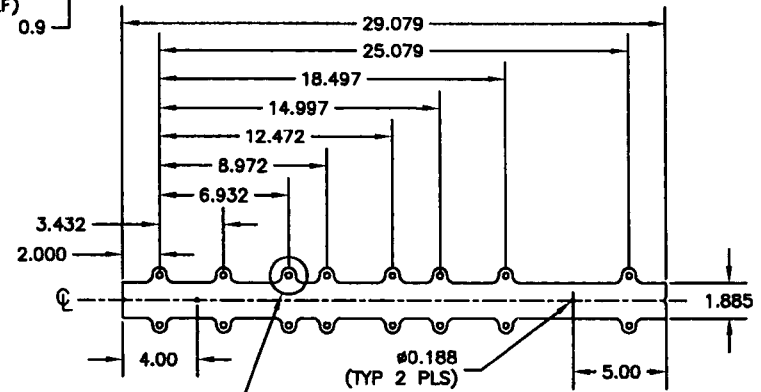
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
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DATE	TITLE	SHEET 6 OF 7
07.04.17	WEARSHOE	SCALE
		1:10



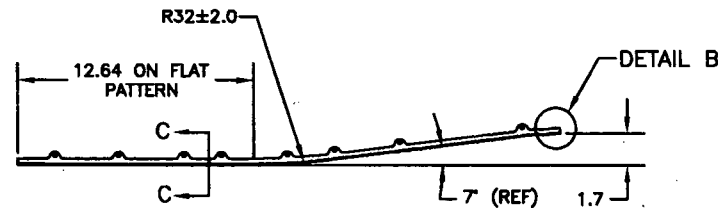
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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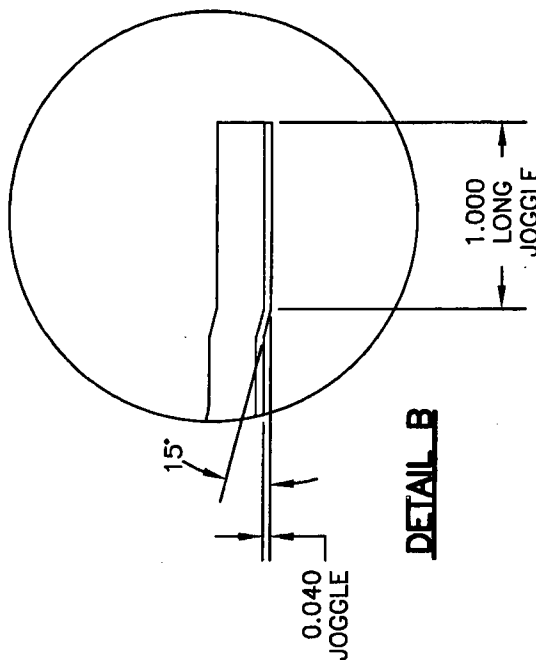


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

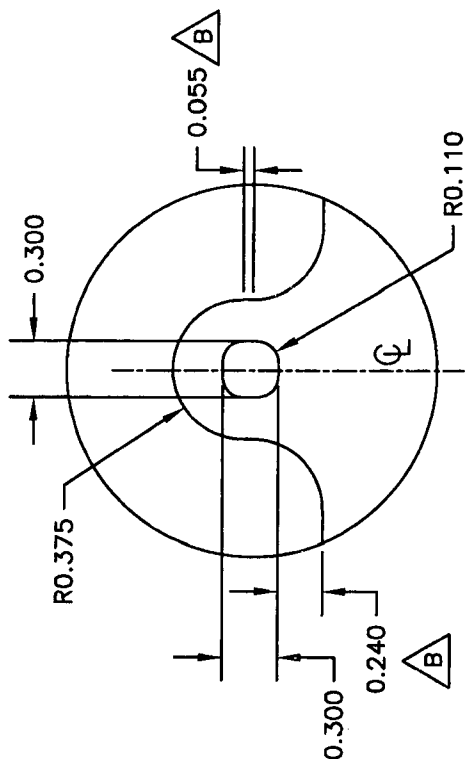
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07.04.24

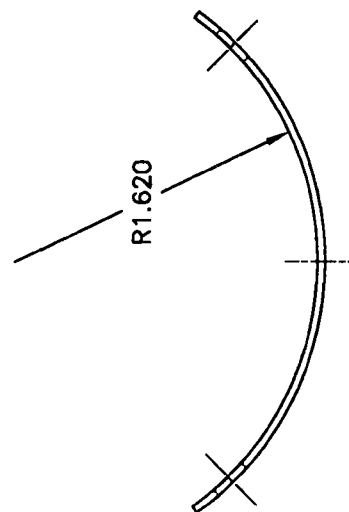
0365930



DETAIL B



DETAIL A



SECTION C-C

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